

Work Order ID 85574

June-11-12 11:06:32 AM

85574

Page 1

Item ID: D3848-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: GASKET

Start Date: 11/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/11

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3848

B

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3848

Dwg Rev: B

Prog Rev: _____

2-Deburr if necessary

12-6-13

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-6-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Item ID: D3848-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: GASKET

Start Date: 11/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: **PPZ**

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

XV

4

Sub 12/06/13

12/6/14

MS 12/06/13

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Picklist Print

June-11-12 11:06:37 AM

Page 1

Work Order ID: 85574

85574

Parent Item: D3848-5

D3848-5

Parent Item Name: GASKET

Start Date: 11/06/2012

Required Date: 02/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased			No	100	sf	286.1429	3.58	15.07368			

MNEO60S 063

NEOPRENE SHEET 0.063

**

B12-673

Location

Loc Qty

Loc Code

MAT052

286.142884

120948

286.142884

170948

8

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 05574 MCT

12/06/11

D3848-1 GASKET

D3848-3 GASKET





D3848-5 GASKET

D3848-7 GASKET 

RELEASED
12/16/11

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
(REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3848-X" USING YELLOW PAINT MARKER
- 7) WEIGHT:
D3848-1 = 0.36 lbs
D3848-3 = 0.44 lbs
D3848-5 = 0.51 lbs
D3848-7 = 0.36 lbs

B	RE-DESIGN Ø0.400 WAS SLOT HOLE ON D3848-1/3/5 (ZN C4-2, A4-2, A8-2, C4-3, A7-3); ADD D3848-7 (ZN B2-1 & A4-3); 66.87 WAS 67.36 (ZN B4-2)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3848	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GASKET	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

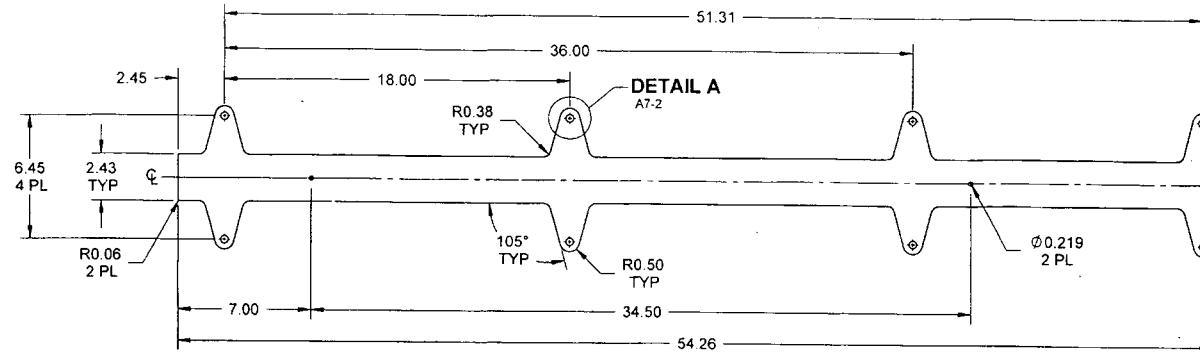
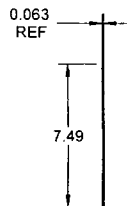
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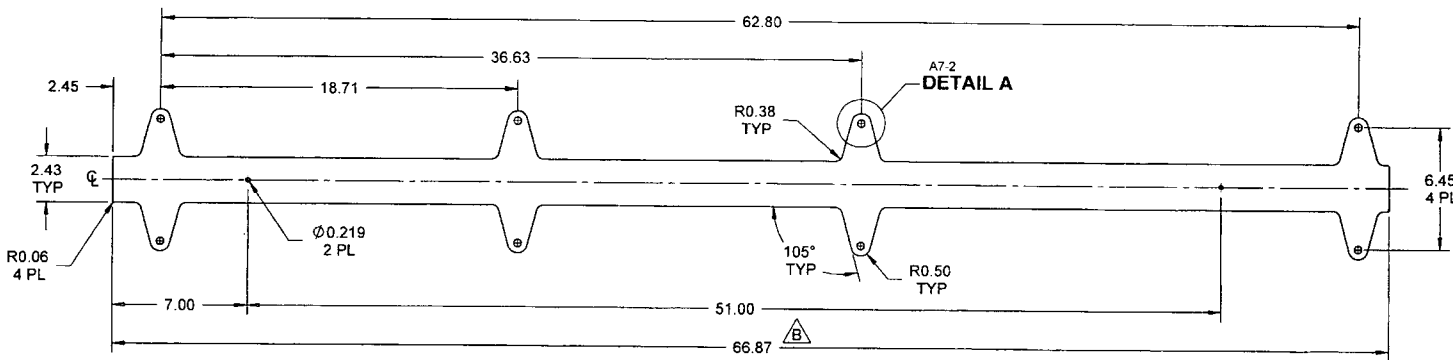
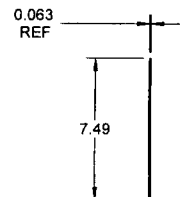
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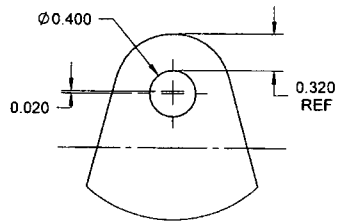
NOTE: Date & initial all entries



D3848-1 GASKET



D3848-3 GASKET



DETAIL A: SLOT DETAIL
TYP

D4-2
C3-2
D2-3
B3-3

RELEASED
10/15/13

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MFG. APPR.	RF	D3848	SHEET 2 OF 3
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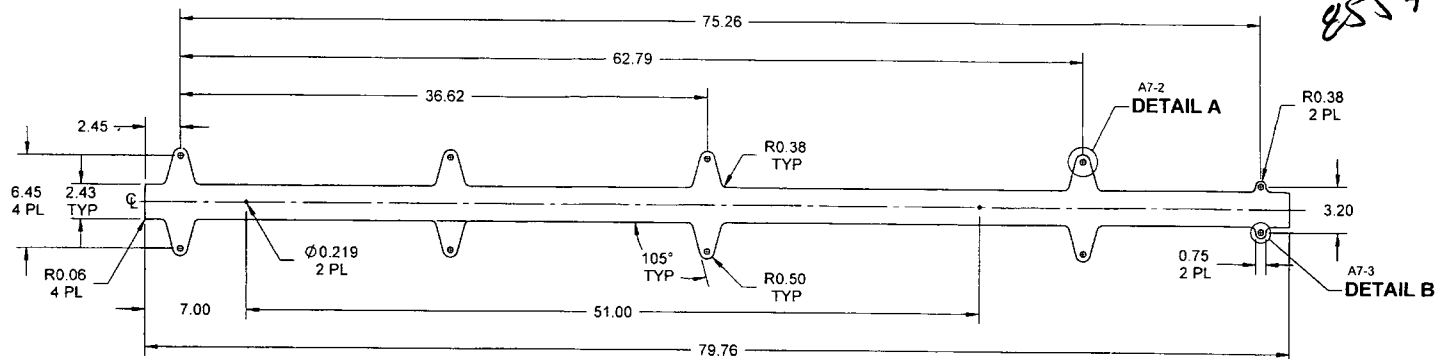
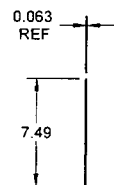
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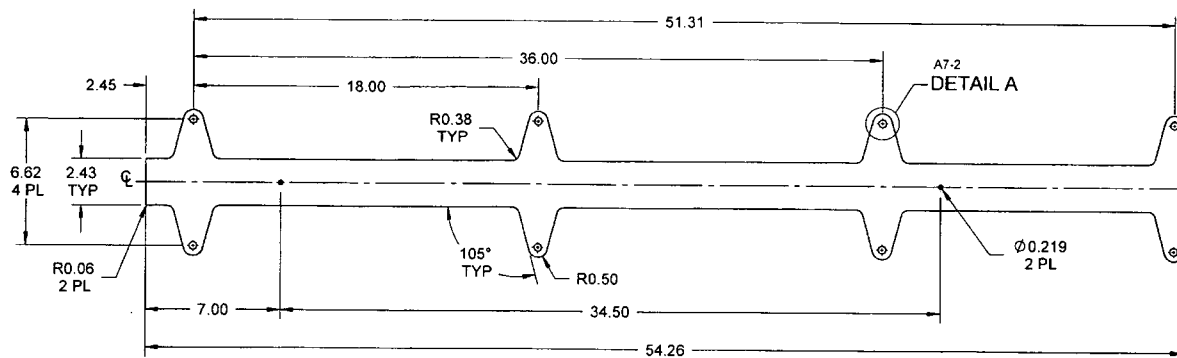
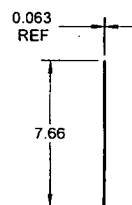
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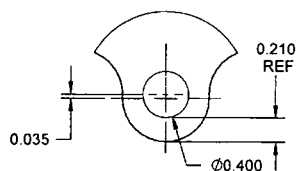
NOTE: Date & initial all entries



D3848-5 GASKET







D3848-7 GASKET



DETAIL B: SLOT DETAIL C1-3
TYP

RELEASED
8/27/12-1M

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3848	SHEET 3 OF 3
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